	er ID 87884 7, 2012 12:58:38 PA	M			Page 1						
Item ID: Revision ID: Item Name:	D412-704-041  Pedal Assembly (205.	/212/214/412)		Accept	*N900	<b>040</b>	100	<b>)*</b> s	Setup Sta	1/1	S1*
Start Date: Required Date Reference:	7/17/2012 Star	t Qty: 1.00 d Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				<sup>в</sup> *N	S2*
Approvals: Process Plan: QC:		MF	Date: Q-07-	Tooling:  SPC (Y/N):	Date:			R	Run Sta	" [ <b>V</b> ]	R1* R2*
Sequence ID/ Work Center I	-	ration ription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision I	Nbr									
D412-704-04	l Rev B										1
*160	,			0.00				100	$\mathcal{D}$		9
Small Fab Small Fab		Memo PULL FRO X1 B 85954	M STOCK D412-704-041	0.00				(IX)	/		L_L4
			03205-1 X 1 B 83937 BACK INTO STOCK (TO	BE USED FOR ANOTH	ER ORDER )				Ĺ		
		REPLACE '	WHEN AVAILABLE			,	*				

QC5- Inspect part completeness to step on W/O

0.00

\*170\*

Memo

Quality Control

0.00

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	2	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor.  Rec/Store/Packaging			Engineering Quality Other
Root					Descri	ption of work order update	lr	nitial	Α	ction	Sign &			
Cause	ĺ	Date	Step	Qty	i	or Non-conformance	1	ef Eng	Des	cription	Date	Verification		QC Inspector
Doc/Data										· · · · · · · · · · · · · · · · · · ·			il	
Equip/Tooling														
Operator			<u> </u>											
Material														
Setup					1									
Other														
Process									<u> </u>	•				
Supplier									ľ					
Training '														
Unapproved							<u> </u>		·		<u> </u>		<u> </u>	
							AUL.	T CATE	GORY	·			ļ <del></del>	
Landi	_	ì			_	General					٦	Г	<u> </u>	
		Bending			<u> </u>	Bend		Grain			Ovalized	-	<del></del>	ressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	$\vdash$	Hardwa		_	Over/Under	<del>}-</del>		emperature/Cure
	_	Cracks				Broken/Damaged	1	•	ion Incomplete	,, , <u> </u>	Part Incorre	<del>-</del>		Veld
	$\overline{}$	Crushed/	Crimped.		<u> </u>	Burrs	-		tions Incomplete	e/Unclear	Part Lost/M	-	<u></u>	Vrong Stock Pulled
1	-	Cuffs			<u> </u>	Contamination			enance	<u> </u>	Part Moved		ı	
		Heat Treat				Countersink	-	Mislab		-	Positioned \		$\neg$	) than
	_	Inspection		Tube	<u> </u>	Cut Too Short		Misrea Offset	a		Power Loss,	Surge	Ic	Other
	Ripples in Bend  Torque Waves in Extrusion					Drill Holes	$\vdash$		Calibration					
		Turning S			" ├	Drawing Finish			Sequence					
		_	•			Folio	$\vdash$		e Dimensions					
1	1	Wave/Twist in Tube Folio						Cutside	C DITTENSIONS					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 87884 \*87884\* Page 2 Tuesday, July 17, 2012 12:58:38 PM D412-704-041 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Pedal Assembly (205/212/214/412) Stop **Start Date:** Start Qty: 1.00 \*1\* 7/17/2012 **Cust Item ID: Required Date:** 7/17/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Start Process Plan: Approvals: Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp Identify as per dwg & Stock Location 180 0.00 \*180\* Packaging 0.00 Memo Packaging

0.00

0.00

190

QC

\*190\*

Quality Control

QC21- Final Inspection - Work Order Release

Memo

mr 12-07-27

DQA:	Date:	

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

	,								QA Closed:	Date	· · · · · · · · · · · · · · · · · · ·				
Work Orde	r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No.					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality				
NCR No.					Use-as-is Work Order Update	The	Finishing Composite	Rec/Store/Packaging Other Supplier							
Root				Descri	ption of work order update	Initial	Δ	Action	Sign &						
Cause	Date	Step	Qty	(	or Non-conformance	Chief Er	ng Des	scription	Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling											1				
Operator						ĺ									
Material															
Setup		l													
Other	_														
Process	_						İ	• .							
Supplier															
Training							ľ		•						
Unapproved							<u> </u>	·	<u> </u>						
<del></del>						AULT CA	regory								
Landin	<del></del>			_	General			. —	7	r	<del>-</del> 1				
	Bending				Bend	Grai			Ovalized		Pressure/Forced				
	Centre No	ot Concer	ntric to C	D/S	BOM/Route	Hard			Over/Under		Temperature/Cure				
1	Cracks			<u> </u>	Broken/Damaged	<b></b> 1	ction Incomplete	·	Part incorre		Weld				
	Crushed/Crimped				Burrs	_	uctions Incomplete	e/Unclear	Part Lost/M		Wrong Stock Pulled				
_	Cuffs				Contamination		ntenance		Part Moved						
1	Heat Treat				Countersink	<b>-</b>	beled	.	Positioned \		<del></del>				
	Inspection	•	Tube	<u> </u>	Cut Too Short	Misr		L	Power Loss,	/Surge	Other				
	Ripples in		$\vdash$	Drill Holes	Offse										
	Torque W		\	Drawing	-	of Calibration		· · · · · · · · · · · · · · · · · · ·	•						
	Turning S	-		lacksquare	Finish	<b> </b>	of Sequence			'					
i i	Wave/Tw	ist in Tuł	ne .		Folio	I lOuts	ide Dimensions			1					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

87884

Parent Item:

Comments:

D412-704-041

Parent Item Name:

Pedal Assembly (205/212/214/412)

IPP Rev:B05.01.28Removed hardware on Step 2; Added Figures 1-3KJ/RF Re-format EC

IPP Rev:C06.03.08 IPP Rev:D 07-03-20

Added Dwg D412-704-041 07-03-20 JLM

Reformat

IPP Rev:E 07.05.02

EC

**Start Date: 7/17/2012** 

Start Qty: 1.00

Required Date: 7/17/2012

Required Qty: 1.00

I	PP Rev:F 08-10-	-08 as per revB	DD v	eriifed by:EC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3205-1 Pedal Bracket	-	Manufactured	No	·			Each	2.0000		-1			
				<u>Location</u> GA	_	Loc Oty 2	<u>Lo</u>	c Code	8	<u> 393</u>	7 -	M	12-07-
D3205-1 Pedal Bracket		Manufactured	No	8393	7	2	Each	2.0000		1	Bu	267	be.
				<b>Location</b> GA		Loc Qty 2	<u>Lo</u>	c Code			BE	7680	8(10)
<b>D412-704-041</b> Pedal Assembly (205/212/2)	14/412)	Manufactured	No	8393	7	2	Each	3.0000		1			
				Location ST203	$\sim$ $_{1}$	Loc Oty	<u>Lo</u>	c Code		N- (	7/17	-/7	<del>= <u>-</u> =</del>

NCR:	Yes	1	Nο

												DQA:	Dat	te:¦	
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
QA Closed: Date:													· · · · · · · · · · · · · · · · · · ·		
Vork Ord	ar.					۱	DISPOSITION			AGAINST D	)EP	ARTMENT/	PROCESS		
VOIK OIG	٠٠.	-				ı	Rework	ı 1		Skid-tube Crosstube	$\neg$		Water Jet	1	Engineering
Part I	do.						Scrap			Machining Small Fab	$\dashv$	Proc	I. Eng. Coor.		Quality
rarer	•0.					ı	Use-as-is			noforming Finishing	-		e/Packaging		Other
NCR I	No.						Work Order Update		********	Large Fab Composite	┪	,	Supplier		
					***************************************		'	ı						T	
Root					Desc	rip	tion of work order update	١	nitial	Action	Т	Sign &			
Cause	ė	Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description		Date	Verificatio	n l	QC Inspector
oc/Data														j	
uip/Tooling											ı			Ţ	
perator															
laterial															
etup										·	- 1				
ther														1	
rocess										·				i	
upplier														1	Í
raining			- 1											1	
napproved								<u>L</u> _			$\perp$			-	
								AUL	T CATE	GORY		<u> </u>		<u> </u>	
Landi	ng (	1			_		General		1	Г	_				1
	<u> </u>	Bending			Ļ	_	Bend	<u> </u>	Grain	<b> </b>	-	Ovalized		<u> </u>	Pressure/Forced
	_	Centre No	ot Concer	ntric to (	o/s	_	BOM/Route	<u> </u>	Hardwa	<b>⊢</b>	$\neg$	Over/Under		<b> </b>	Temperature/Cure
	<u> </u>	Cracks	Broken/Damaged					<u> </u>	4	ion Incomplete		Part Incorred		_	Weld
		Crushed/0	Crimped.		-		Burrs	<u> </u>	4	tions Incomplete/Unclear	_	Part Lost/Mi	ssing	L	Wrong Stock Pulled
		Cuffs Contamination					<u> </u>	4	enance	$\dashv$	Part Moved				
	_	Heat Treat Countersink						_	Mislabe	į.		Positioned V	- 1		la.,
	<u> </u>	Inspection Strip in Tube Cut Too Short						$\vdash$	Misrea	d [	لــ	Power Loss/	Surge	L	Other
	<u> </u>	Ripples in				_	Drill Holes	<u> </u>	Offset						
		Torque W			n	1	Drawing	<b> </b>	4	Calibration	-	<del></del>	<del></del>		
	<u> </u>	Turning Se			L	_	Finish	<b>—</b>	Out of Sequence						
	l	Wave/Tw	ist in Tut	oe e	1		Folio		Outside	e Dimensions			<u>j</u>		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## Pieklist Print

June-19-12 8:03:31 AM

Work Order ID: 85954

Parent Item:

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

\*85954\*

\*D412-704-041\*

Start Date: 19/06/2012

Start Qty: 4.00

\*\*

Required Date: 03/07/2012

Required Qty: 4.00

AN960JD416L

NAS1149D0416J Purchased

FP002

Location

Location

GA

Loc Oty

Each

Loc Code

2.0000

6.0000

110153

82593

83991

100

100

Each

\*\*

D3204-041

\*D3204-041\*

Release Pedal Assembly

D3205-1

Pedal Bracket

**Back Plate** 

Manufactured

Manufactured

GA

Manufactured

2 Each

Loc Oty

8.0000

7.0000

Loc Code

\*\*

Loc Code 83937

100 Each

\*\*

Location Loc Oty Loc Code GA 82060 2

100

June-19-12 8:03:31 AM

**Shop Packet Print** 

Page 3

									DQA:	Date	
NCR: . Y	es / No	, ,			WORK ORDER NON-C	ONFOR	MANCE / UPDATE		·		
		i.i.						.,	QA Closed:	Date:	
Work Orde	, a <b>r:</b>				DISPOSITION		AGAINS <sup>-</sup>	/PROCESS			
					Rework		Skid-tube Crosstube	۔ ا		Water Jet	Engineering
Part N	, lo.				Scrap		Machining Small Fat	$\vdash$	Pro	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming Finishing	-		re/Packaging	Other
NCR N	lo.				Work Order Update		Large Fab Composite	_	·	Supplier	
				*					•		
Root					ption of work order update	Initial	Action		Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief En	Description Description		Date	Verification	QC Inspector
Doc/Data					•					<u>'</u>	
Equip/Tooling	_										
Operator											
Material							4.				
Setup					•	ł					
Other										1	
Process	_										
Supplier											
Training											
Unapproved						L CAT	FCORV	· · · · · · · · · · · · · · · · · · ·	l		
Landi	ng Gear		,		General	AULT CAT	EGORY				
Lanuii	Bending				Bend	Grain		Γ	Ovalized		Pressure/Forced
	Centre No	nt Conce	ntric to 1		BOM/Route		vare ॣॏ	<b> </b>	Over/Under	tolerance	Temperature/Cure
	Cracks	or concer	יינויני נטי	· · ·	Broken/Damaged	<del></del>	tion Incomplete	-	Part Incorre	<del>];</del> -	Weld
	Crushed/	Crimped		-	Burrs		ctions Incomplete/Unclear		Part Lost/M	<del> </del>	Wrong Stock Pulled
	Cuffs	c.impeų.		<b>—</b>	Contamination	$\vdash$	tenance	-	Part Moved		
	Heat Tres	at .		-	Countersink	Mislal			Positioned \	ļ	•

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short Drill Holes

Drawing

Finish

Folio

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

